

Split-1

Work Order ID 132702-1

132702

Page 1

Thursday, May 07, 2015 2:55:31 PM

Item ID: D3537-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearpad

Stop *NS2*

Start Date: 5/7/2015

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: CG Date: MAR 08 2015

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3537	D
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D3537-3 as per Dwg D3537

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

(44) _____ 02/15/05/12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(44) _____ 02/15/05/12

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132702

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Item ID: D3537-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 5/7/2015

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						(44)			
QC	Memo	0.00							
Quality Control									MAY 14 2015
130	Form as per dwg	0.00							
130	NC BRAKE				DAS	44X			
Brake NC	Memo	0.00			30				
Brake NC					9-89				15/05/14
140	QC5- Inspect part completeness to step on W/O	0.00							
140						(44)			
QC	Memo	0.00							
Quality Control									DAS 38 9-89 MAY 20 2015

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NS1

NS2

Customer:

NR1

NR2

**Insp.
Stamp**

24 1563 E/MA

A/R 2059B Hardcoat BATCH: 130852

24 _____ 38
9-8

Quality Control

1111 05 2015

24 _____

Quality Control

JUN 05 2015

Work Order ID 132702

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132702

Page 4

Item ID: D3537-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 5/7/2015

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: FP001

0.00

200

Packaging

Memo

0.00

Packaging

LOCATION : FP001

424 6 211 6/06/05

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

ML5 JUN 05 2015ML5 JUN 05 2015

Picklist Print

Thursday, May 07, 2015 2:55:30 PM

Page 1

Work Order ID: 132702

132702

Parent Item: D3537-3

D3537-3

Parent Item Name: Wearpad

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	318.7176	0.149	6.273684			

M304S16GA

304/316 Sheet .063

8.6

02/15/05/13

Location

Loc Qty

Loc Code

MAT019

318.7176

m131384

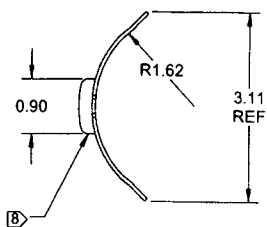
121.4176

m131503

197.3

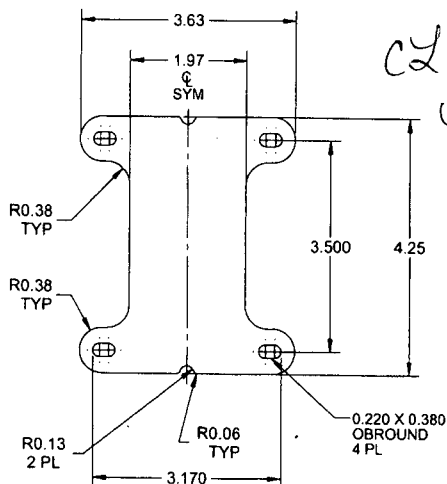
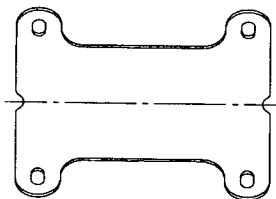
6.6

2



D3537-1 WEARPAD
(MAKE FROM D3537-1F)

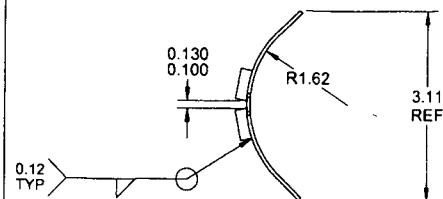
0.25
TYP



D3537-1F FLAT PATTERN

NOTES:

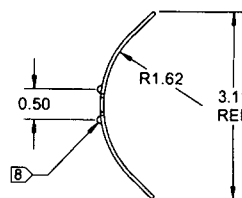
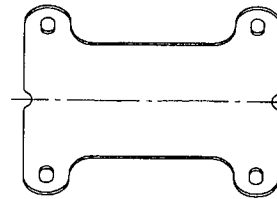
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-1" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.42 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-5 WEARPAD
(MAKE FROM D3537-1F)

NOTES:

- 1-5) AS PER D3537-1
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-5" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.42 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-9 WEARPAD
(MAKE FROM D3537-1F)

NOTES:

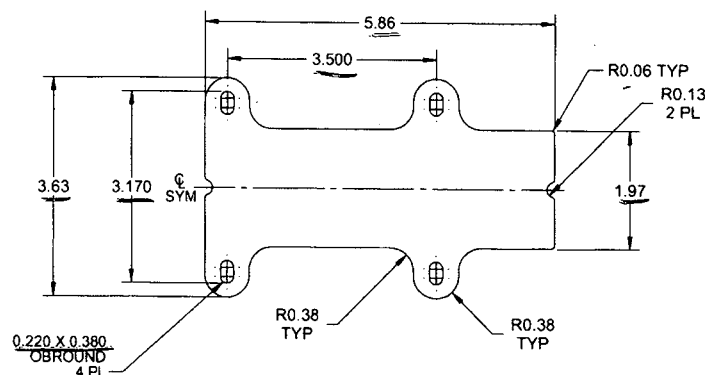
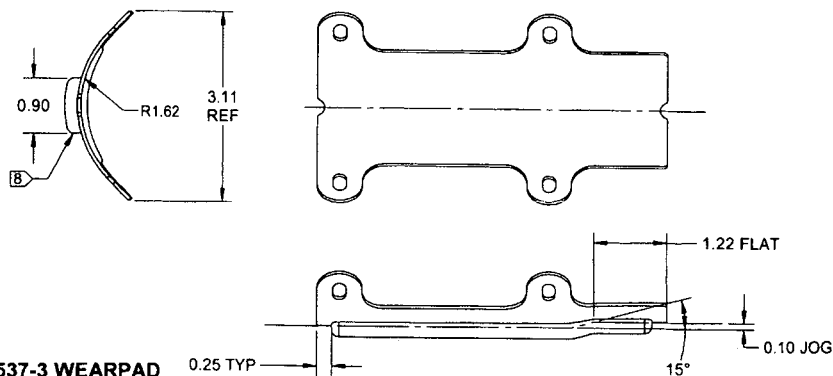
- 1-5) AS PER D3537-1
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-9" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.19 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WELD PATTERN	CB	07.04.13
B	ADD AMS 5513 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	06.11.06
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO. D3537	
MFG. APPR.	DD	REV. D	
APPROVED	MP	SHEET 1 OF 2	
DE APPR.	DS	TITLE WEARPAD	
DATE	14.10.16	SCALE NTS	

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RELEASED
2014-11-05

D3537-3 WEARPAD
(MAKE FROM D3537-3F)

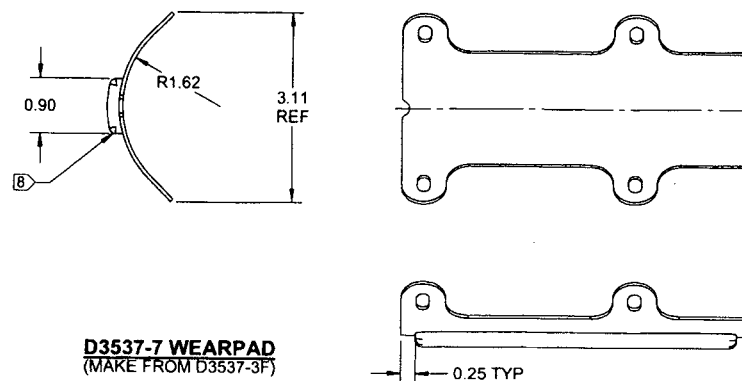


D3537-3F FLAT PATTERN

NOTES:

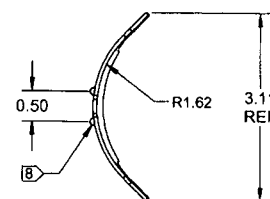
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-3" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004

D3537-7 WEARPAD
(MAKE FROM D3537-3F)



NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-7" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-11 WEARPAD
(MAKE FROM D3537-3F)

NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-11" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.25 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

APPROVED

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	D3537	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
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RELEASED
2014-11-05

FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD	Work Order:	132702
Description: u-202 pad	Number:	3537-3
Inspection Dwg: 3537		
Rev: D		Page 1 of 1